

Date: Monday, 4/2/2007 2:29:20 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 31566		
Estimate Number	: 12814		
P.O. Number	: N/A	Part Number	: D31464
This Issue	: 4/2/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3146 UNDER REVIEW
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: U/R
Written By	: <i>[Signature]</i>	Material	: N/A
Checked & Approved By	: <i>[Signature]</i>	Due Date	: 4/9/2007
Comment	: Est Rev:A New Issue 07-04-02 JLM	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 0.2931 Each(s)/Unit Total: 0.2931 Each(s)

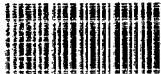
Material: D6102-013

Identify for D3146-4

Batch: *B28911*

[Signature] 07-04-02 ①

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 4.500" x 1.250" x 3.100" long Bar

[Signature] 07-04-02 ①

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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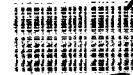
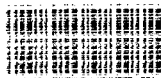
Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Dwg D3146

Identify as D3146-4

[Signature] 07-04-03 ②

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

MILL AS PER DWG D3146

[Signature] 07-04-03 ①

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-04-03 ②

Date: Monday, 4/2/2007 2:29:20 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31566

Part Number: D31464

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



Eng Approval CB 07.04.03



Comment: SECOND CHECK

07.04.03

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr and Tumble

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l

07/04/03

9.0

POWDER COATING

POWDER COATING



N/103706



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/04/03

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/04/03

x1

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m-l 07/04/03

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



U 07/04/05

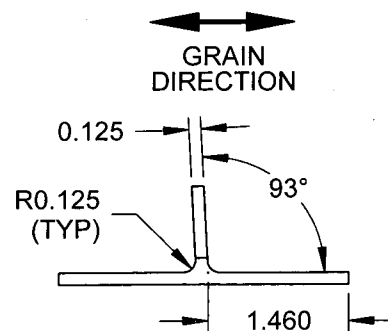
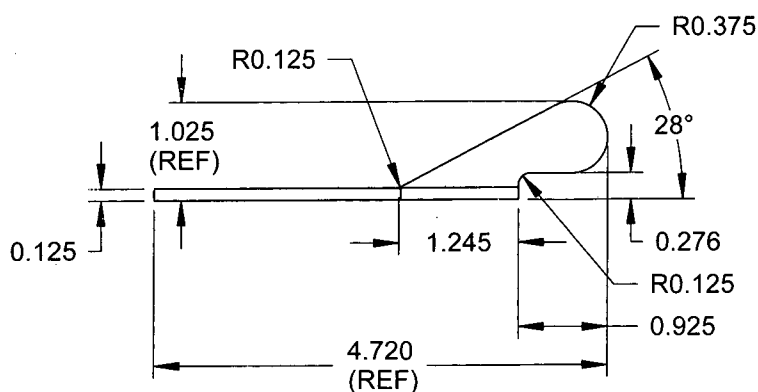
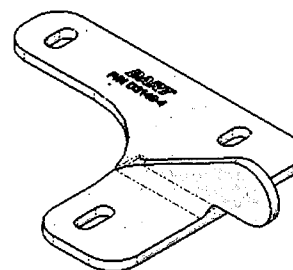
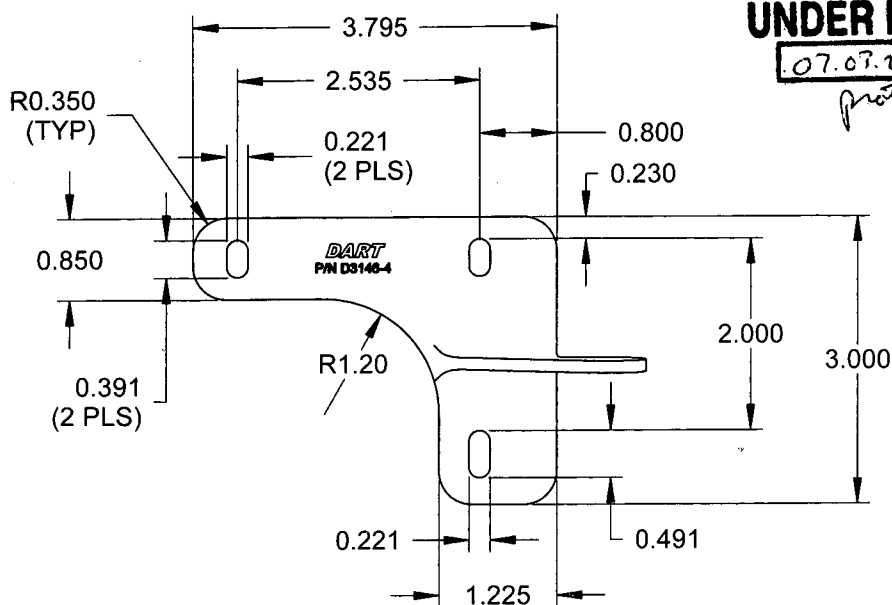
PRELIMINARY ISSUE

DESIGN <i>AF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED	DRAWING NO. D3146	REV. B SHEET 2 OF 2
DATE 07.03.28		TITLE BRACKET	SCALE 1:2

UNDER REVIEW

07.07.28 CB

prototype



B28811

D3146-4 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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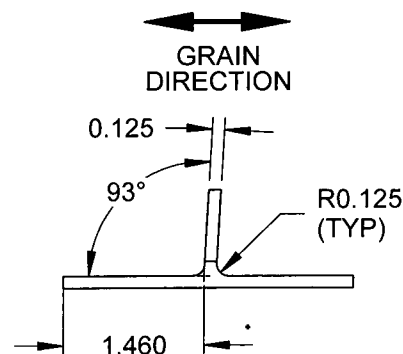
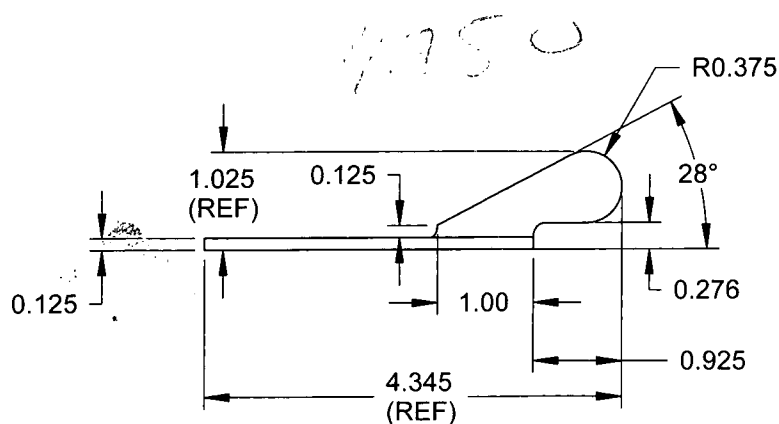
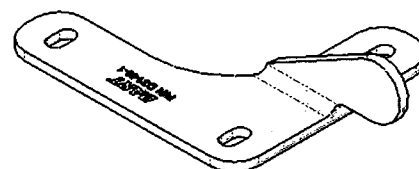
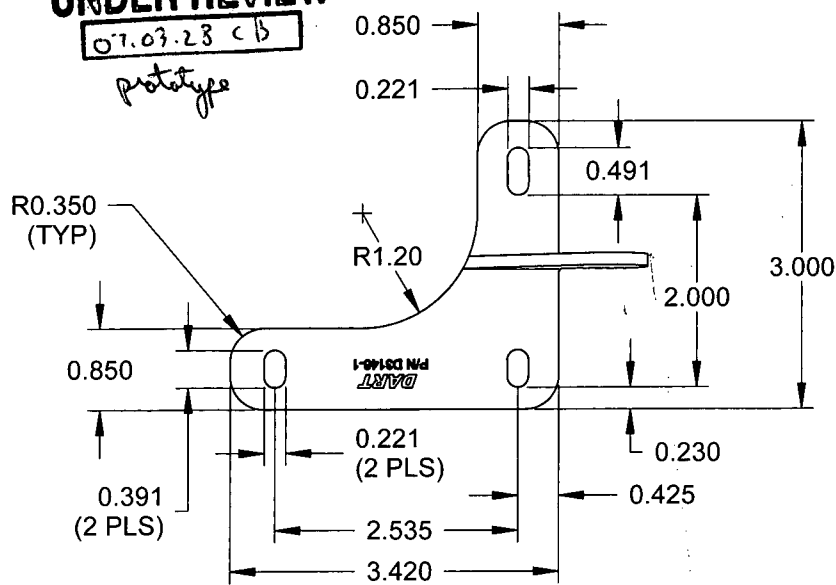
PRELIMINARY ISSUE

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3146	REV. B SHEET 1 OF 2
DATE 07.03.28		TITLE BRACKET	SCALE 1:2
REV	DATE	DESCRIPTION	
A	02.04.25	NEW ISSUE	
B	07.03.28	ADD -4; ROTATED LOGO AND P/N	

UNDER REVIEW

07.03.28 CB

prototype



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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DART AEROSPACE LTD		Work Order:	
Description: <i>Bracket</i>		Part Number:	<i>D3146-4</i>
Inspection Dwg: <i>D3146</i> Rev: <i>B</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>3.795</i>	<i>±0.010</i>	<i>3.796</i>	<i>-</i>			
<i>2.535</i>	<i>±0.010</i>	<i>2.535</i>	<i>-</i>			
<i>.221</i>	<i>±0.010</i>	<i>.223</i>	<i>-</i>			
<i>.800</i>	<i>±0.010</i>	<i>.799</i>	<i>-</i>			
<i>.230</i>	<i>±0.010</i>	<i>.228</i>	<i>-</i>			
<i>3.000</i>	<i>±0.010</i>	<i>2.996</i>	<i>-</i>			
<i>.491</i>	<i>±0.010</i>	<i>.490</i>	<i>-</i>			
<i>1.225</i>	<i>±0.010</i>	<i>1.216</i>	<i>-</i>			
<i>.850</i>	<i>±0.010</i>	<i>.848</i>	<i>-</i>			
<i>.391</i>	<i>±0.010</i>	<i>.389</i>	<i>-</i>			
<i>.125</i>	<i>±0.010</i>	<i>.128</i>	<i>-</i>			
<i>.125</i>	<i>±0.010</i>	<i>.133</i>	<i>-</i>			
<i>.925</i>	<i>±0.010</i>	<i>.924</i>	<i>-</i>			
<i>R.125</i>	<i>±0.010</i>	<i>R.125</i>	<i>-</i>			
<i>.276</i>	<i>±0.010</i>	<i>.278</i>	<i>-</i>			
<i>1.025</i>	<i>±0.010</i>	<i>1.024</i>	<i>-</i>			
<i>93°</i>	<i>±0.5°</i>	<i>93°</i>	<i>-</i>			
<i>1.460</i>	<i>±0.010</i>	<i>1.462</i>	<i>-</i>			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>CB</i>
Date: <i>07.04.03</i>	Date: <i>07.04.03</i>	Date: <i>07.04.03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	